



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4853-7

Job Sheet 170422



Part No: D4853-7

Job Qty: 12 ea

Part Name: Top Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/26/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: D4853 REV.B SHEET 4 IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.04 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Waterjet2		SC 18/01/25
100	Waterjet	12 pcs	1/25/18	1/25/18	0.00	3.00	Waterjet1		SC 18/01/25
120	QC	12 pcs	1/25/18	1/25/18	0.00	0.00	QC2 Waterjet-4		SC 18/01/25
125	Mill Conv	12 pcs	1/25/18	1/25/18	0.00	6.00	Mill Conv 2		J.L. 18-01-24
130	QC	12 pcs	1/25/18	1/25/18	0.00	0.00	QC8-7		B.A 18-01-31
140	HandFinish	12 pcs	1/25/18	1/25/18	0.00	0.32	HandFinish1		B-01-31
150	QC	12 pcs	1/25/18	1/25/18	0.00	0.00	QC7-4		B.F.B 18-02-01
160	Powdercoat	12 pcs	1/26/18	1/26/18	0.00	0.12	Powdercoat1		BK 18-02-01
170	QC	12 pcs	1/26/18	1/26/18	0.00	0.00	QC3		1 FEB 01 2018
180	Packaging	12 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-2		D4853-7L SC
190	QC21-SA	12 Ea	1/26/18	1/26/18	0.00	0.00	QC21		21 FEB 01 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 125 - MILL RADS DRILL HOLES AS PER DWG USE DT10105 ,ORIENT FIXTURE WITH RED FACE ON SAME SIDE WHEN FLIPPING FIXTURE FROM SIDE TO SIDE DEBURR

160 - START TIME: 1:20 OVEN TEMPERATURE: 320° FINISH TIME: 1:50

M 138467

FH127797

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X04.000	5	21	0	0

(5)

DPF3
1.5

DART
AEROSPACE
S035829



Top Bracket

PART NO: D4853-7
Original Serial #: S035829
Revision:
Operation:
Change No:

Start up Operation 01/26/18

Job No: 170422

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Top Bracket	0.750Inches ± 0.030	0.780 0.720		0,755
2	Top Bracket	0.300Inches ± 0.030	0.330 0.270		0,304
3	Top Bracket	0.500Inches ± 0.030	0.530 0.470		0,504
4	Top Bracket	0.250Inches ± 0.030	0.280 0.220		0,251
5	Top Bracket	1.250Inches ± 0.030	1.280 1.220	Radius	1,250
6	Top Bracket	0.130Inches ± 0.030	0.160 0.100	Radius	0,130
7	Top Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	 0.258
8	Top Bracket	3.800Inches ± 0.005	3.805 3.795		3,800
9	Top Bracket	4.550Inches ± 0.030	4.580 4.520		4,532
10	Top Bracket	0.380Inches ± 0.030	0.410 0.350	Radius	0,385
11	Top Bracket	0.060Inches + 0.040 - 0.000	0.100 0.060	Radius	0,060

J.C.-L.
18-01-24

Qc8

L.A 18-01-31

Plex 1/16/18 11:16 AM dart.lavoie.chantal